·WK 5/35

DART AEROSPACE LTD

Work Order: 23978

Description: Wearpad

Part Number: D2648-3

Dwg: D2648 Rev. D

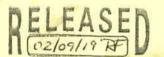
Qty: 400

Page 1 of 1

Sflif

Step	Location	Procedure	By	Date	Qty	
1_	DC	Issue Traveller RF 03.05.12	1	V 00 E		
		Dug not required	17	05.08,08	400	
2	PG	Issue P/0:200 8447				
100		Email or ship DXF file to vendor		1		
114	4	Make per Drawing D2648-1	()	05.08010	40	
3	RG	Material release note required Receive and Inspect for transit damage	U	0120000	70	
0	11.0	Ensure the material release note attached	d9.	5/08/25	400	
4	QC6	Inspect dimensions	11	2008/22	700	
	39.5.5		M E	5h8/15	400	
5	GA	Deburr if necessary	041	Tuope		
		MA	SI	05/09/01	401	
6	GB	Form as per Dwg D2648 on CNC brake using Jigs DT 8261	50	17	1	
	14/0	and DT 8326 and identify as D2648-3	SB	10/96/01	401	
7	WS	Weld as per Dwg D2648 using Jig DT 8210				
		Qty Description Batch A/R 7560Hardcoat 17914018	228		- 29	
	100	7500 Tall decoat 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	EPL	05-10-27	204	5
8	WS	Remove any weld that penetrated through Wearpad	PP	0)1021	10	_
	- Heat	if necessary.	Ca	05.10.27	201	5
9	QC9	Inspect weld	AI	11		
		181	LA !	05/10/27	205	
10	QC5	Inspect work to Step 9	1/4	111	0	
44	FP	2 1 2 10 (21 7010)	1	05/10/27	205	see)
11	FF	Powder Coat Grey (RAL-7012) (Ref. 4.3.5.5) per QSI 005 4.3	ml	2/ 1/ 02	125	(spirt)
12	QC3	Inspect Powder Coat	///	06 01 25	IN	(c)
12	QUS	mapect Fowder Coat	CL	Xe101/24	155	
13	FP	Identify and Stock	1	4101/31	100	
213			M	06 01 24	15	
14	AC	2 1/ 1/	1	0 2001	0	7.
		Cost/part the did not close when		06.02.28	4	1125
15	DC	Cost/part Su did not close when 1 Close W/O Rec'E	(B	DI lest -	125	
	330	Inspect Level 21		06/01/25	125	

Rev	Date	Change	Revised By	Approved
A	97.12.04	all and and and and		- 1
В	99.04.09	Re-format	DM	
С	00.06.22	Removed P/O for powder coat	EC	Λ
D	00.11.15	Removed Bending	EC	
Ε	02.09.18	Re-format; Incorporated D2648-1	KJ R	X



W/O:	0 1 1	WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector						

NCR:			WORK ORI	DER NON-CONFORMANCE	(NCR)			
		Description of NC		Corrective Action Section B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Section C	Approval Design Mgr	Approval QC Inspector	
								18
2 2 2 1	e e							
								7.0
								100
u-ae n-								
				ſ				*

Part No:	PAR #:	Fault Category: NCR:	Yes No DQA:	Date: Oblox	25	
NOTE: Date & initia! all entries			QA: N/C Closed:	Date:	c	

Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Aug 08, 2005 10:50 am

Work Order No	:	0023978	B
Project Name	:	D2648-3	

Project For : WK535 Work Order Type : Main

Main WO Number : House Part Number: D2648-3

Description : Wearpad Manufactured : Yes

Amount Req'd: 400
Amount Done: 0
Start Date: 08-08-05

Start Date Est Finish Date : 08-31-05

Act Finish Date : Drawings Regd : No Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number : Invoice Amount: 0.00

Order Entry No :

OE Value : 0.00

Est Mark Up : 0.000% Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours		0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours		0.00	0.00	0.00		
CNC		0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
. MARC		========	=======			
Burden	:	0.00	0.00	0.00		
		========	========	======		
Total Cost	: 1	0.00	0.00	0.00		
Mark up	:	0.000	0.000			
Selling Cost	:	0.00	0.00			
					Sign	

Actual Estimated Labour Hrs/Amount Done 0.00 0.00 0.00 Profits/(Less)



New Zealand Steel Limited Clenbrook, South Auckland Postat: Private Bug 92121, Auckland, New Zealand Telephones: (09) 375 8999 / 375 8111 Auckland (09) 235 8069 / 235 3535 Walsau Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5078/21768

ZIFFF							V.					N. SCHOOL SECTION	Contons	enter/L		CACOC VICE								1 C -01
USTOMER	Wilkinson P501280T003						1	SPECIFICATION ASTMA1908 CS Type A							7	CERTIFICATE No TC109561								
USTOMER O/N 90-21N-540					i	PROD	UCT		CRA WIDE COIL					PAGE 1 of 1										
WILL O/N	471159	Account named assessment assessme										DIME	NSIO	NS	0.055" × 48" × Coil					DATE 23 April 2005				
Audalia Indonesia		1000	entra d	abiti de	(CHEMI	CALC	ОМРО	SITIO	N PER	CENT						ME	CHANICAL	TESTS (T	EST SPECIFI	CATION -	ASTMA3	370)
PACK NUMBER		C	Si	Mo	P	s	Cu	Ni	Cr	Мо	٧	Nb .	Ti	Al	B N2	CE()	BEND	YIELD	T.S	ALTER SO	HARDNESS	r	LENGTH	
	HEAT NO x100		x1000 x1000						x10000 x100			180° G.L.= F			HRB	()	(feet)							
89-457097-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1				Good			1	46		1562	
9-457098-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1	1			Good			1	46		1483	
29-457099-00	640590	4	TR	20	13	17	12	17	20	1.	8	1	1				Good		1	11	46		1562	
19-457100-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1		P.		Good		1		47		1496 1562	
19-457101-00	640590	4	TR	20	13	17	12	17	20	1	8	1			i i		Good			1	47		1555	
R9-457102-00	640590	4	TR	20	13	17	12	17	20	1	8	1					G000			-			1.000	

YIELD	GAUGE LENGTH	1(G.L.)	2	PLASTIC S	STRAIN RATIO (r)	IMPACT TEST	(C)=5mm x 5mm	CARBON EQUIVALENT VALUE (CE)	(C)=C+Mn/6+Si/24	i
(A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	(A)=200mm (C (B)=50mm (C	C)=80mm D)=5.65 - So		(A)=r0 (B)=r90	(C)=r45 (D)=(r0+r90+2r45) / 4	(A)=10mm x 10mm (B)=7.5mm x 10mm	(D)=2.5mm x 10mm (E)=5mm x 10mm	(A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Moy/5+(Cu+Ni)/15	(D)= (D)=	

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED Satish Mista

16 90 cms

